

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026374**Date Inspected:** 20-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay 14

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08587.

Ultrasonic Testing (UT)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

Seg3019K-021, 023, 025, 027, 029, 030, 031, 032, 033, 034

FB3271-001-136, 017

WELDING

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020B-054 located on side plate to floor beam of the OBG Segment 14W. The welder is identified as 047866. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AQ-002 located on anchor plate of the OBG Segment 14W. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AP-029 located on anchor plate of the OBG Segment 14W. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AL-121 located on side plate I-rib of the OBG Segment 14W. The welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3168-001-062 located on deck plate of the OBG Segment 14W. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3014C-155 located at PP121.55 of the OBG Segment 13BW. The welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020M-001 located on deck plate of the OBG Segment 14W. The welder is identified as 066002. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AJ-284 located on bottom plate I-rib of the OBG Segment 14W. The welder is identified as 067707. ZPMC Quality Control (QC) is identified as Mr. Zhan Lin. The welding variables recorded by QC appeared to

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

comply with WPS-B-P-2212-Tc-U4b-FCM-1

Submerged Arc welding (SAW)

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as DP3168-001-002 located on deck plate of the OBG Segment 14W. The welder is identified as 067993. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

During random in process observations of OBG Segment 14W, this QA inspector observed ZPMC personnel making groove by air-carbon-arc-cutting method on joint located on Edge Plate (EP3030E) to Edge Plate (EP3030D) of OBG Segment 14W. This QA performed Visual Testing (VT) of the joint and found that appeared to be in general compliance with the applicable contract documents. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
